

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-008925**Date Inspected:** 08-Sep-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Xian Ping**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG & TOWER Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Sandeep Kumar was present during the times noted above for observations relative to the work being performed.

BAY 2

This QA Inspector observed the following work in progress:

FCAW process welding of weld joint #031 located on Floor Beam FB3043 – 001. Welder is identified as 045203. ZPMC QC is identified as Zhang Hai Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132 – 3.

FCAW process welding of weld joint #024 located on Floor Beam FB3074 – 001. Welder is identified as 045203. ZPMC QC is identified as Zhang Hai Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2133.

FCAW process welding of weld joint #032 located on Floor Beam FB3043 – 001. Welder is identified as 045203. ZPMC QC is identified as Zhang Hai Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132 – 3.

FCAW process welding of weld joint #025 located on Floor Beam FB3074 – 001. Welder is identified as 045203. ZPMC QC is identified as Zhang Hai Feng. The welding variables recorded by QC appeared to comply with the

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WPS – B – T – 2133.

BAY 5

This QA Inspector observed the following work in progress:

FCAW process welding of weld joint #003 located on Traveler Rail 11TR1 – 019. Welder is identified as 217805. ZPMC QC is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – B – U2 – F.

FCAW process welding of weld joint #004 located on Traveler Rail 11TR1 – 019. Welder is identified as 215689. ZPMC QC is identified as Xu Hong Min. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – B – U2 – F.

FCAW process welding of weld joint #003 located on Traveler Rail 11TR1 – 020. Welder is identified as 217805. ZPMC QC is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – B – U2 – F.

FCAW process welding of weld joint #004 located on Traveler Rail 10TR3 – 020. Welder is identified as 215689. ZPMC QC is identified as Xu Hong Min. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – B – U2 – F.

BAY 6

This QA Inspector observed the following work in progress:

SMAW process welding of weld joint #1A located on WD1 – A305 – 53M – 4. Welder is identified as 048659. ZPMC QC is identified as Zhang Bao Bo. The welding variables recorded by QC appeared to comply with the WPS – 345 – SMAW – 2G (2F) FCM – Repair.

SMAW process welding of weld joint #2A located on WD1 – A305 – 53M – 3. Welder is identified as 067707. ZPMC QC is identified as Zhang Bao Bo. The welding variables recorded by QC appeared to comply with the WPS – 485 – SMAW – 2G (2F) FCM – Repair – 1.

SMAW process welding of weld joint #10A located on WD1 – A305 – 53M – 1. Welder is identified as 049769. ZPMC QC is identified as Zhang Bao Bo. The welding variables recorded by QC appeared to comply with the WPS – 345 – SMAW – 2G (2F) FCM – Repair.

SMAW process welding of weld joint #2A located on WD1 – A305 – 53M – 1. Welder is identified as 053753. ZPMC QC is identified as Zhang Bao Bo. The welding variables recorded by QC appeared to comply with the WPS – 485 – SMAW – 2G (2F) FCM – Repair – 1.

BAY 7

This QA Inspector observed the following work in progress:

FCAW process welding of weld joint #010 located on Side Plate SP3026 – 017. Welder is identified as 051246.

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ZPMC QC is identified as Zhou Jie. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132 – 3.

FCAW process welding of weld joint #007 located on Side Plate SP3026 – 017. Welder is identified as 209554. ZPMC QC is identified as Zhou Jie. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132 – 3.

FCAW process welding of weld joint #014 located on Side Plate SP3026 – 017. Welder is identified as 205774. ZPMC QC is identified as Zhou Jie. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132 – 3.

TRIAL ASSEMBLY

2BW

Magnetic Particle Testing

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The members are identified as OBG Components.

HOLD BACK WELDS (TAG#2)

This QA Inspector observed the following work not in compliance:

During random verification Magnetic Particle Testing (MT) of the OBG Floor Beam located in SEG 2BW, observed One (1) longitudinal linear indication. The indication lengths measured approximately 5mm to 6mm in length. The Floor Beam is identified as FB015-001-004.

For Further details please see the incident report: - 040120F4_TL-15_B227_09-08-09_ (MT) Longitudinal Linear Indications.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No Relevant Conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang - 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Kumar,Sandeep	Quality Assurance Inspector
Reviewed By:	Prue,Erik	QA Reviewer
